

Work Order ID 110581

Thursday, January 02, 2014 10:14:31 AM

110581

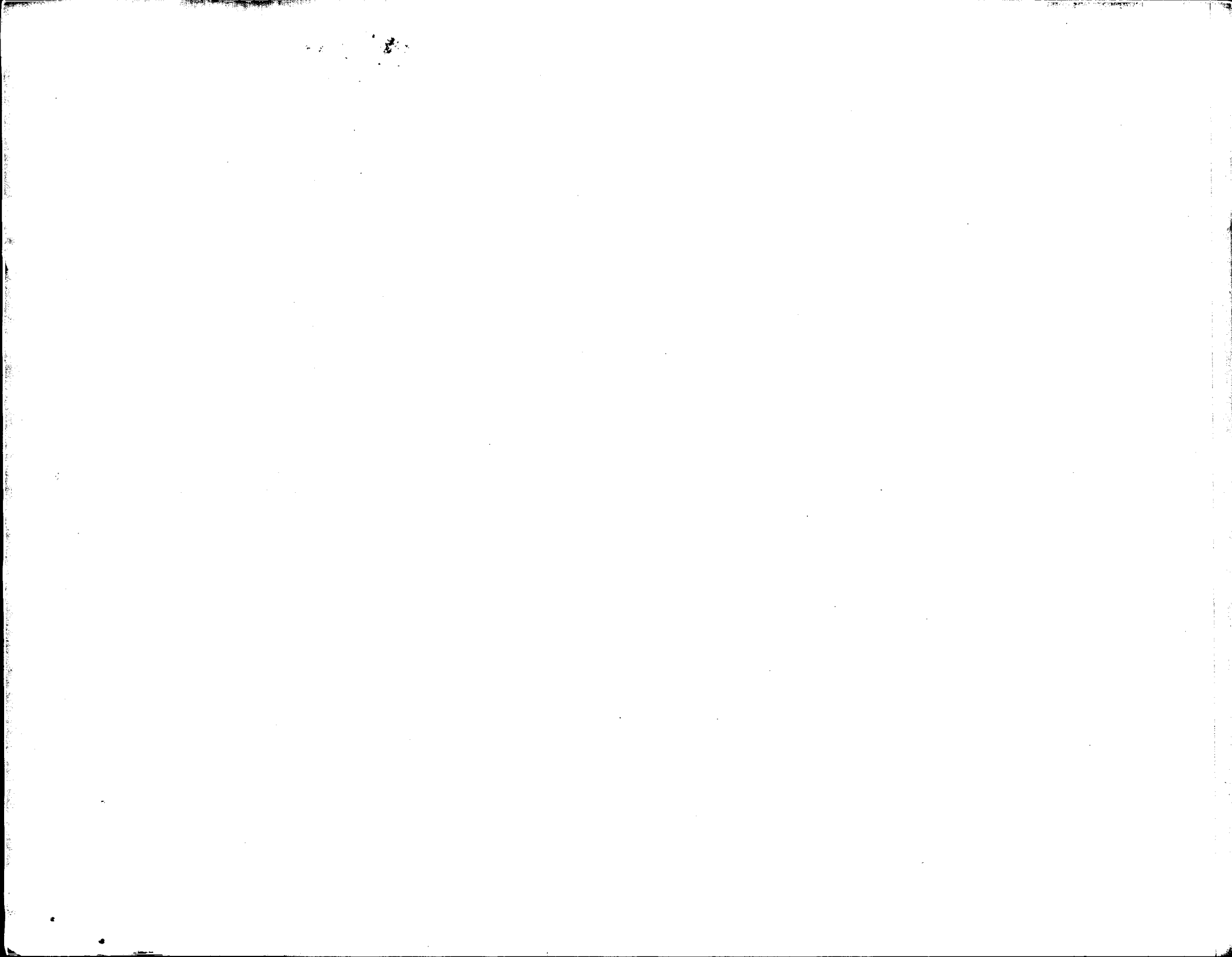
Page 1

Item ID: D4881-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Leg Assembly, RH
Start Date: 1/2/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/31/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: SMF Date: 14-01-02 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4881	A								

110 0.00
110 1 FF
Small Fab Memo 0.00 14-04-17
Small Fab
ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-2 AND
D4885-3. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER
DWG.
REAM EACH HOLES USING REAMER, USING DART TOOL SETUP
DT9974 AS PER DWG.
DAS
27
1-39
110 QC5- Inspect part completeness to step on W/O 0.00 14/4/17
120
QC Memo 0.00 1
Quality Control



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Page 2

Item ID: D4881-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Leg Assembly, RH
 Start Date: 1/2/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/31/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Small Fab	Memo	0.00							FF
Small Fab	INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9974 A/R HYSOL BATCH: <u>17128703</u> Exp. Date <u>JUN 2015</u>								14-04-17
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>ST139B</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									

DAS
28
9-89

APR 17 2014

Work Order ID 110581***110581***

Page 3

Thursday, January 02, 2014 10:14:31 AM

Item ID: D4881-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Leg Assembly, RH
Start Date: 1/2/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/31/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MCS 14-01-21

R14-4-21

Picklist Print

Thursday, January 02, 2014 10:14:30 AM

Page 1

Work Order ID: 110581

Parent Item: D4881-042

Parent Item Name: Aft Leg Assembly, RH

Start Date: 1/2/2014

Required Date: 1/31/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4881-1 Strut		Manufactured	No		111339		Each	0.0000		1		FF 14-04-17	
D4885-2 End Fitting		Manufactured	No		B 112033		Each	0.0000		1		FF 14-04-17	
D4885-3 End Fitting		Manufactured	No		112034		Each	0.0000		1		FF 14-04-17	
HL20PB5-12 Rivet		Purchased	No		120110		Each	0.0000		4		FF 14-04-17	
HL86-5 Collar		Purchased	No		120110		Each	21.0000		4		FF 14-04-17	

Location

Loc Qty

Loc Code

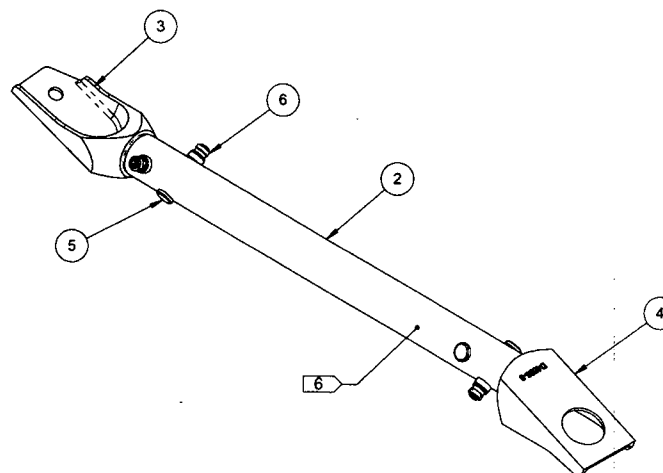
ST283

21

121866

21

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4881-041	AFT LEG ASSEMBLY, LH
2	1	D4881-1	STRUT
3	1	D4885-1	END FITTING
4	1	D4885-3	END FITTING
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4881-041 AFT LEG ASSEMBLY, LH

NOTES:

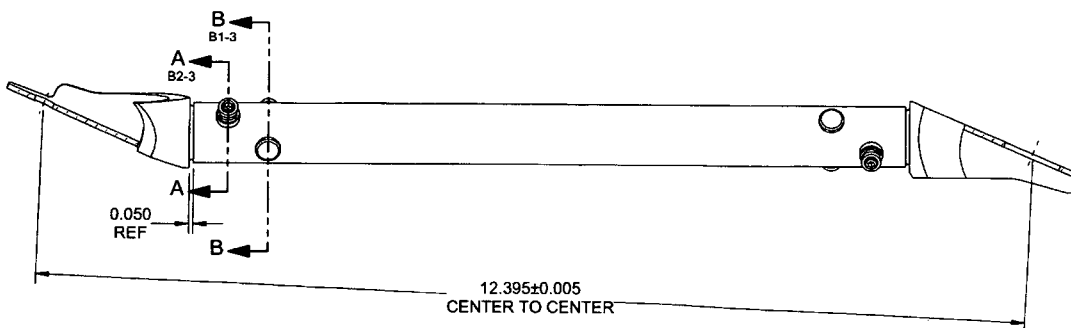
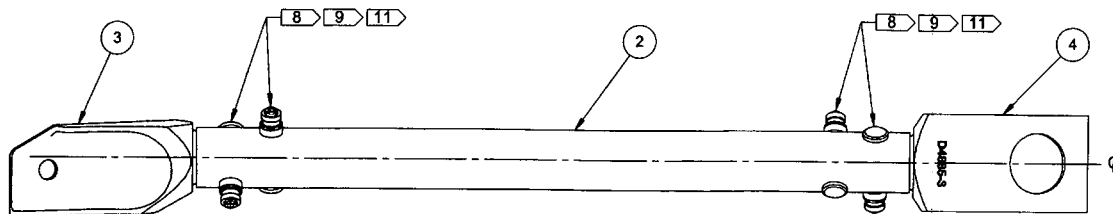
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.72 lbs
- 8) ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-1 & D4885-3.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9973
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9973
- 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

MF
14-01-02
110581

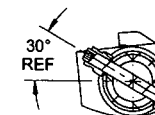
2013-12-12
MD

APPROVED

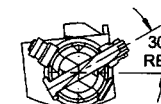
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DRAWN	RF			SHEET 1 OF 5	
CHECKED	DC	DRAWING NO.		SCALE	
MFG. APPR.	JLM	D4881		NTS	
APPROVED	HS	TITLE		SCALE	
DE APPR.	DS	LEG ASSEMBLY		NTS	
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D4881-041 AFT LEG ASSEMBLY, LH
AUXILIARY VIEW



SECTION A-A C7-3
2 PL SIMILAR



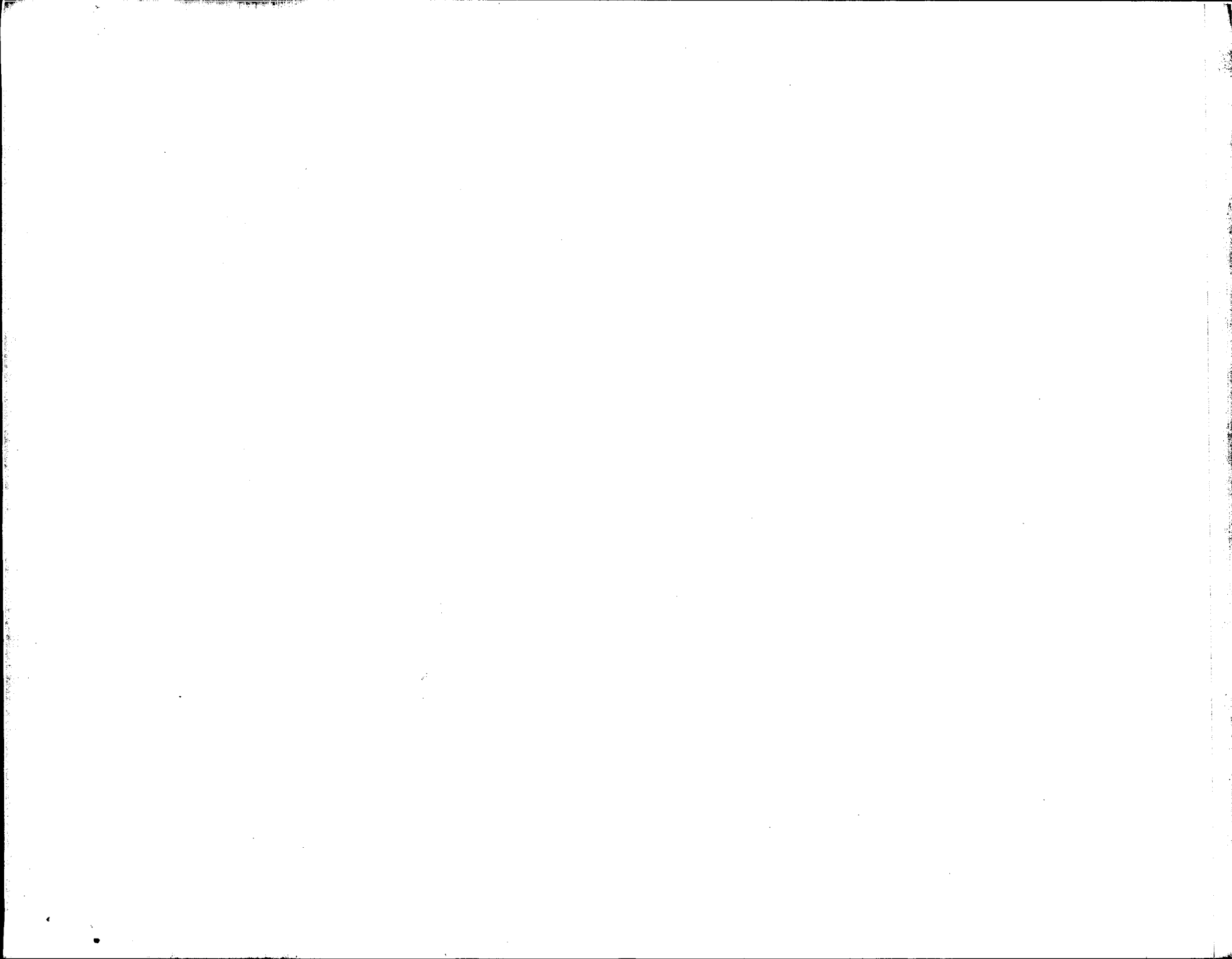
SECTION B-B C7-3
2 PL SIMILAR

110581

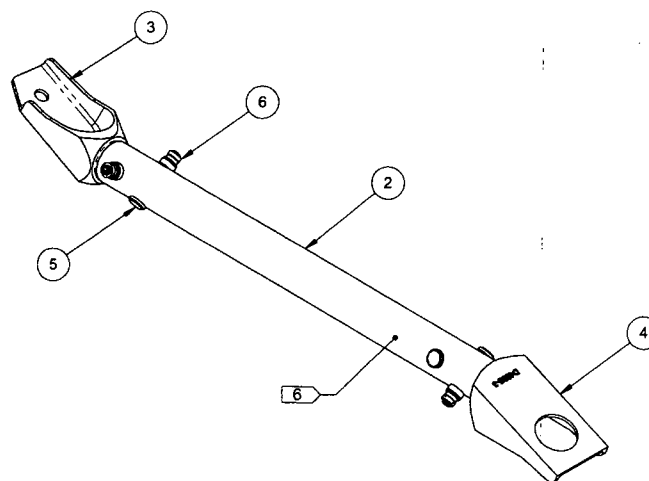
2013-12-12

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CHECKED	DC	DRAWING NO. D4881	REV. A
MFG. APPR.	JLM		SHEET 2 OF 5
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ITEM NO.	QTY. -042	PART NUMBER	DESCRIPTION
1	X	D4881-042	AFT LEG ASSEMBLY, RH
2	1	D4881-1	STRUT
3	1	D4885-2	END FITTING
4	1	D4885-3	END FITTING
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4881-042 AFT LEG ASSEMBLY, RH

NOTES:

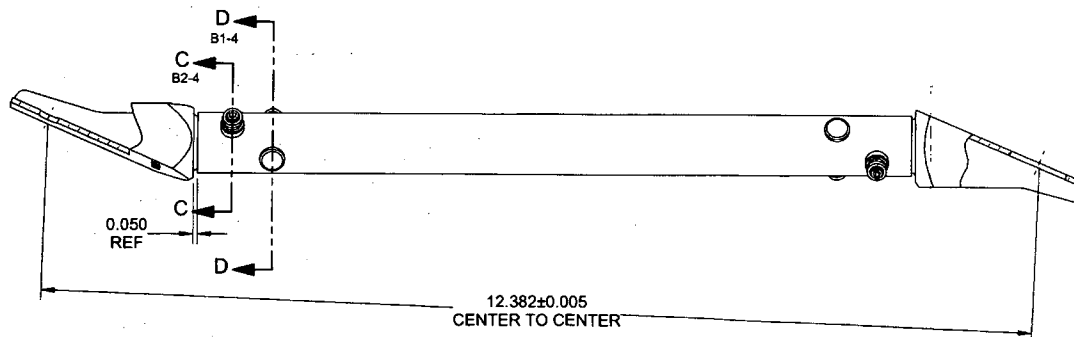
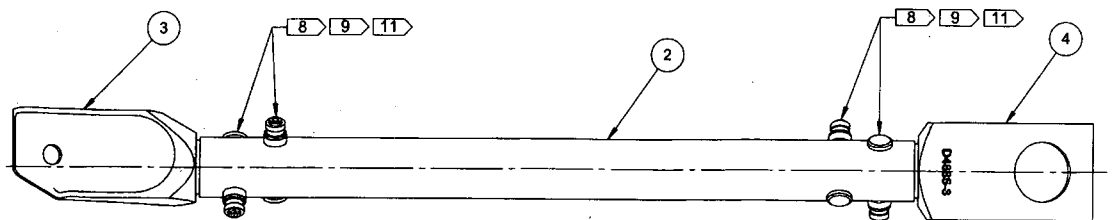
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.78 lbs
- 8) ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-2 & D4885-3.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9974
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9974
- 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

APPROVED

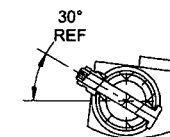
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CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4881	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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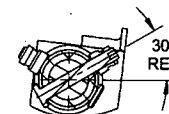
2013-12-12
WP



D4881-042 AFT LEG ASSEMBLY, RH
AUXILIARY VIEW



SECTION C-C C7-4
2 PL, SIMILAR



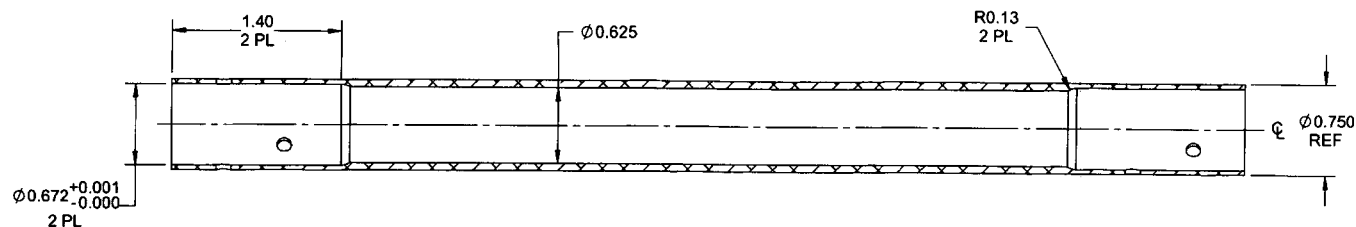
SECTION D-D C7-4
2 PL, SIMILAR

#110581

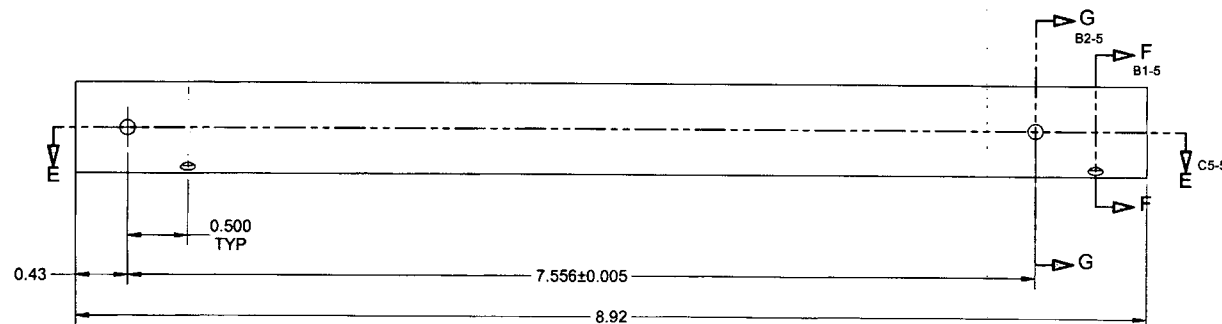
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MFG. APPR.	JLM	D4881	SHEET 4 OF 5
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DE APPR.	DS	LEG ASSEMBLY	NTS
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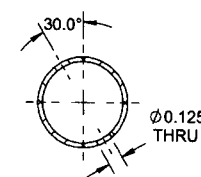
SECTION E-E B3-5



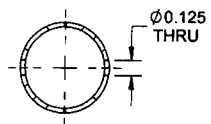
D4881-1 STRUT

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)



SECTION F-F C3-5
2 PL



SECTION G-G C3-5
2 PL

110581

RELEASED
2013-12-12
WJD

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	DRAWN	RF		
	CHECKED	DC	DRAWING NO. D4881	REV. A
	MFG. APPR.	JLM		SHEET 5 OF 5
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	LEG ASSEMBLY	NTS
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